

What Is Claimed Is:

1. A method of making a one-piece microsurgical instrument comprising:

5 providing a metal blank with a narrow, elongate shaft with a center axis and an axial length between opposite first and second ends of the shaft, and with a block of the metal at the shaft second end, the shaft and the block being one piece of the metal;

10 cutting the one piece of metal with a wire of a wire electrical discharge machine by moving the one piece of metal and the wire relative to each other with the wire moving through the block and cutting the block into two separate pieces; and,

moving the wire through the shaft in a first direction parallel to the shaft center axis from the shaft second end toward the shaft first end and cutting a slot in the shaft.

2. The method of Claim 1, further comprising:

the wire moving through the shaft in the first direction subsequent to the wire cutting the block into two separate pieces.

3. The method of Claim 1, further comprising:

5 the wire moving through the shaft in a second direction that is opposite to the first direction and is parallel to the shaft center axis, the wire moving through the shaft in the second direction subsequent to the wire moving through the shaft in the first direction.

4. The method of Claim 3, further comprising:

the cutting of the slot in the shaft consisting of moving the wire in the first and second directions through the shaft.

5. The method of Claim 3, further comprising:

the wire moving through the shaft in the first direction along the shaft center axis and in the second direction along the shaft center axis.

6. The method of Claim 1, further comprising:
the wire moving through the shaft in the first direction from the shaft second end toward the shaft first end and the wire stopping short of reaching the shaft first end.
7. The method of Claim 3, further comprising:
prior to the wire moving through the shaft in the first and second directions, the wire moving further through the block in forming at least one operative microsurgical surface of the instrument from the block.
8. The method of Claim 7, further comprising:
forming the at least one operative microsurgical surface with a serrated edge.
9. The method of Claim 7, further comprising:
forming the at least one operative microsurgical surface as opposed gripping surfaces.
10. The method of Claim 7, further comprising:
forming the at least one operative microsurgical surface with a shearing edge.
11. A method of making a one-piece microsurgical instrument comprising:
providing a metal blank with a narrow, elongate shaft with a center axis and an axial length between opposite first and second ends of the shaft, and with a block of the metal at the shaft second end, the shaft and the block being one piece of the metal;
cutting the one piece of metal with a wire of a wire electrical discharge machine by moving the one piece of metal and the wire relative to each other where the wire moves through the block and the shaft with the wire

- 10 positioned in a first orientation relative to the metal blank where the wire is perpendicular to the shaft center axis, and moving the one piece of metal and the wire relative to each other where the wire moves through the block with the wire positioned in a second orientation relative to the metal blank where the wire is perpendicular to the shaft center axis and perpendicular to the first
15 orientation of the wire.

12. The method of Claim 11, further comprising:
moving the one piece of metal and the wire relative to each other where the wire moves through the block with the wire positioned in a third orientation relative to the metal blank where the wire is at an oblique
5 angle to the shaft center axis and to the first orientation of the wire and to the second orientation of the wire.

13. The method of Claim 12, further comprising:
cutting the one piece of metal with the wire of the wire electrical discharge machine with the wire in the third orientation, then with the wire in the first orientation, and then with the wire in the second orientation.

14. The method of Claim 12, further comprising:
moving the wire along the shaft center axis with the wire in the second orientation.

15. The method of Claim 12, further comprising:
cutting serrations in the block with the wire in the first
orientation.

16. The method of Claim 11, further comprising:
cutting operative microsurgical surfaces of the instrument in the block with the wire in the second orientation.

17. The method of Claim 11, further comprising:
cutting operative microsurgical surfaces of the instrument in the
block consisting of moving the wire through the block.
18. The method of Claim 17, further comprising:
cutting at least one of the operative microsurgical surfaces with
a serrated edge.
19. The method of Claim 17, further comprising:
cutting the operative microsurgical surfaces of the instrument as
opposed gripping surfaces.
20. The method of Claim 17, further comprising:
cutting the operative microsurgical surfaces of the instrument as
opposed shearing surfaces.
21. A method of making a one-piece microsurgical instrument
comprising:
providing a metal blank with a narrow, elongate shaft with a
center axis and an axial length between opposite first and second ends of the
5 shaft, and with a block of the metal at the shaft second end, the shaft and the
block being one piece of the metal;
cutting the one piece of metal with a wire of a wire electrical
discharge machine by moving the one piece of metal and the wire relative to
each other with the wire moving through the block cutting serrations in the
10 block.
22. The method of Claim 21, further comprising:
cutting each serration with a width dimension in a range of
0.0015 of an inch to 0.0039 of an inch.

23. The method of Claim 21, further comprising:
cutting each serration with a width dimension of at most
0.0039 of an inch.
24. The method of Claim 21, further comprising:
cutting each serration with a width dimension of at least
0.0015 of an inch.
25. A microsurgical instrument comprising:
first and second operative microsurgical surfaces;
means for manually moving the first and second operative
microsurgical surfaces toward and away from each other; and
5 at least one of the operative microsurgical surfaces having a
series of serrations and each serration having a width dimension smaller than
0.007 of an inch.
26. The microsurgical instrument of Claim 25, further comprising:
each serration having a width dimension of at most 0.0039 of an
inch.
27. The microsurgical instrument of Claim 25, further comprising:
each serration having a width dimension in the range of
0.0015 of an inch to 0.0039 of an inch.
28. The microsurgical surgical instrument of Claim 25, further
comprising:
the series of serrations being a wire electric discharge machined
surface.